

Work Order ID 73468

Thursday, September 01, 2011 7:37:11 AM



Page 1

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH Out, 206

Stop



Start Date: 8/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/09/16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

B.A 11/09/16

6

φ

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

B.A 11/09/16

6

φ

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

B.A 11/09/16

6

φ

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73468

Page 3

Thursday, September 01, 2011 7:37:11 AM

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 8/31/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 4/09/21

170

Identify as per dwg & Stock Location: ST 428 A 0.00

Packaging

Memo

0.00

Packaging

SPSP 11-09-21

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/22MF
11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 7:37:09 AM

Page 1

Work Order ID: 73468

Parent Item: D2938-1

Parent Item Name: Saddle LH Out, 206



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	25.0000	1	6			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

20

72226

20

MAT44

5

72226

5

6 and 11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73468
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.114	.114	.113	Mic	118-120
B	0.100	0.140		.116	.114	.114	.117	"	"
C	0.100	0.140		.114	.112	.114	.115	"	"
D	0.210	0.230		0.225	0.223	0.223	0.223	Vern	GA-01
E	1.245	1.255		1.250	1.250	1.250	1.250	"	"
F	1.245	1.255		1.250	1.250	1.250	1.250	"	"
G	2.495	2.505		2.500	2.500	2.500	2.500	"	"
H	0.510	0.515		0.512	0.512	0.512	0.512	"	"
I	1.572	1.582		1.577	1.577	1.577	1.577	"	"
J	2.495	2.505		2.500	2.500	2.500	2.500	"	"
K	0.257	0.262		0.258	0.258	0.258	0.258	"	"
L	0.312	0.317		0.315	0.315	0.315	0.315	"	"
M	0.235	0.240		0.238	0.238	0.238	0.238	"	"
N	0.100	0.140		0.117	0.115	0.115	0.115	Mic	GA-03
O	0.540	0.560		0.552	0.552	0.550	0.550	Vern	GA-01
P	0.490	0.510		0.501	0.500	0.500	0.500	"	"
Q	3.715	3.725		3.720	3.720	3.720	3.720	"	"
R	2.720	2.760		2.740	2.740	2.740	2.740	"	"
S	0.240	0.270		0.254	0.252	0.253	0.253	"	"
T	0.100	0.180		0.135	0.135	0.135	0.135	"	"
U	1.625	1.635		1.630	1.630	1.630	1.630	"	"
V	1.362	1.372		1.367	1.367	1.367	1.367	"	"
W	0.316	0.321		0.317	0.317	0.317	0.317	"	"
X	1.250	1.270		1.2613	1.2632	1.260	1.260	Dial	HeasZ
Y	1.565	1.585		1.5753	1.5773	1.574	1.574	"	"
Z	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	MA
Date:	11/09/16

Audited by:	cmf
Date:	11/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	73468
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

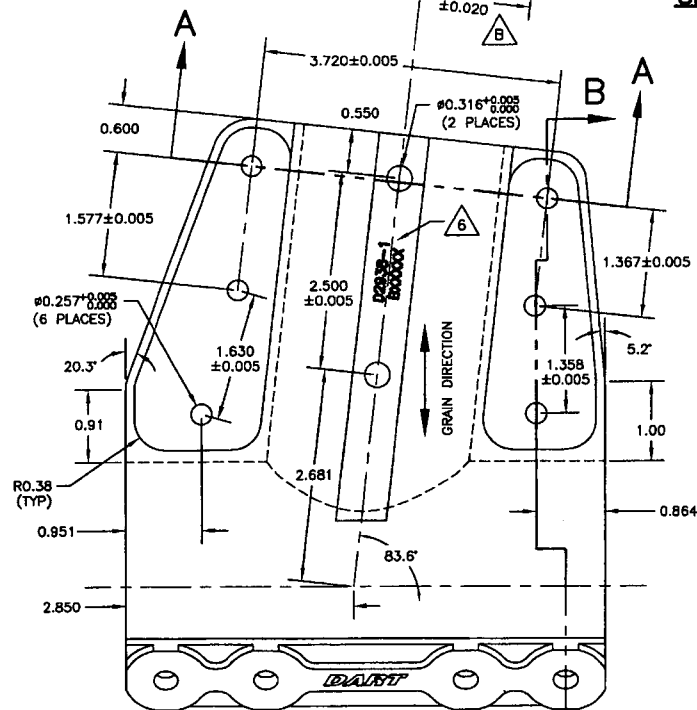
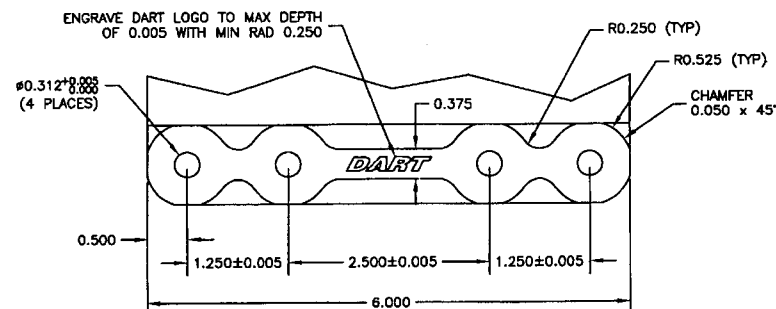
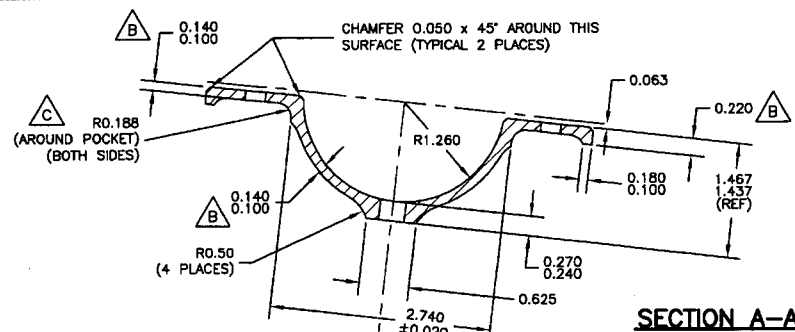
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	#	#	By	Date
A	0.100	0.140		.114	.114			Mic	118-120
B	0.100	0.140		.114	.114			"	"
C	0.100	0.140		.115	.116			"	"
D	0.210	0.230		0.223	0.223			Vern	6A-01
E	1.245	1.255		1.250	1.250			"	"
F	1.245	1.255		1.250	1.250			"	"
G	2.495	2.505		2.500	2.500			"	"
H	0.510	0.515		0.512	0.512			"	"
I	1.572	1.582		1.577	1.577			"	"
J	2.495	2.505		2.500	2.500			"	"
K	0.257	0.262		0.258	0.258			"	"
L	0.312	0.317		0.315	0.315			"	"
M	0.235	0.240		0.238	0.238			"	"
N	0.100	0.140		0.116	0.115			Mic	6A-03
O	0.540	0.560		0.550	0.550			Vern	6A-01
P	0.490	0.510		0.498	0.500			"	"
Q	3.715	3.725		3.720	3.720			"	"
R	2.720	2.760		2.740	2.740			"	"
S	0.240	0.270		0.252	0.252			"	"
T	0.100	0.180		0.135	0.135			"	"
U	1.625	1.635		1.630	1.630			"	"
V	1.362	1.372		1.367	1.367			"	"
W	0.316	0.321		0.317	0.317			"	"
X	1.250	1.270		1.261	1.261			Dial	HAASZ
Y	1.565	1.585		1.574	1.575			"	"
Z	0.178	0.198		0.188	0.188			R-B	ref.
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

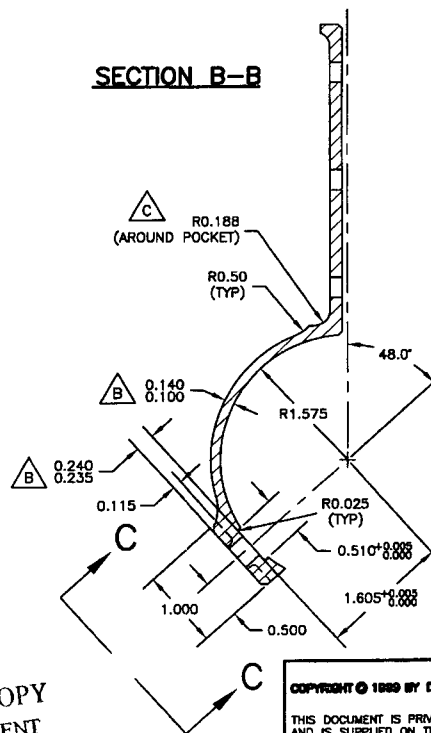
Measured by:	B.E.
Date:	11/09/16

Audited by:	OMK
Date:	11/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION B-B



D2938-1 LH SADDLE (SHOWN) D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	D2938
DATE		SADDLE OUTSIDE
06.11.09		

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07.02.12